

Date: Tuesday, 08/04/2008 12:52:59 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	STEP BRACKET
Job Number :	38468		
Estimate Number :	13161		
P.O. Number :		Part Number :	D37291
This Issue :	08/04/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3729 REVB
First Issue :	/ /	Project Number :	N/A
Previous Run :	37580	Drawing Revision :	B
	Type :	Material :	
	SMALL /MED FAB	Due Date :	15/04/2008
Written By :		Qty:	8 Um: Each
Checked & Approved By :	JD 08.04.08		
Comment :	Est Rev:A 08-01-30 new issue DD verified by:EC Est Rev:B 08-02-26 ECN 1140p DD verified by: Est Rev:C 08-03-19 ecn 1158 DD verified by:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X05000	6061-T6 Bar .50" x 5.0"
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Comment: Qty.: 1.0062 f(s)/Unit Total : 8.0497 f(s)
 6061T6 aluminium bar 5.00" X .50" thick
 (M6061T6B0500X05000)
 Batch: 106182 LB 8-4

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3729
 Dwg Rev: B LB 8-4
 Prog Rev: B

8

2- Deburr if necessary LB 8-4

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

8 08/04/09 (X8)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- open holes to finish size as per dwg D3729

8 08/04/11 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STEP BRACKET

Job Number: 38468

Part Number: D37291

Job Number:



Seq. #:

Machine Or Operation:

Description :

2- Deburr if necessary

3- grind water jet marks all around bracket smooth

****do not grind inside where step extrusion goes****

EB 08/04/15 (8)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EB 08/04/15 (8)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 08-04-15 (8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M. 08/04/15 (8X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: GA

ml 08/04/15

xs

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/17

Job Completion



mf 08-04-16

Dart Aerospace Ltd

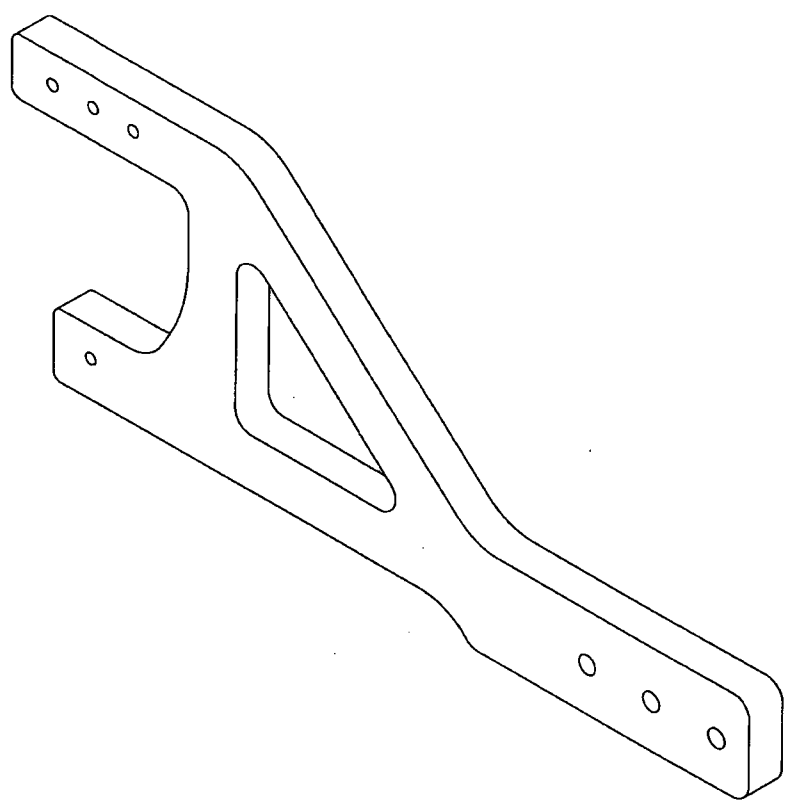
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

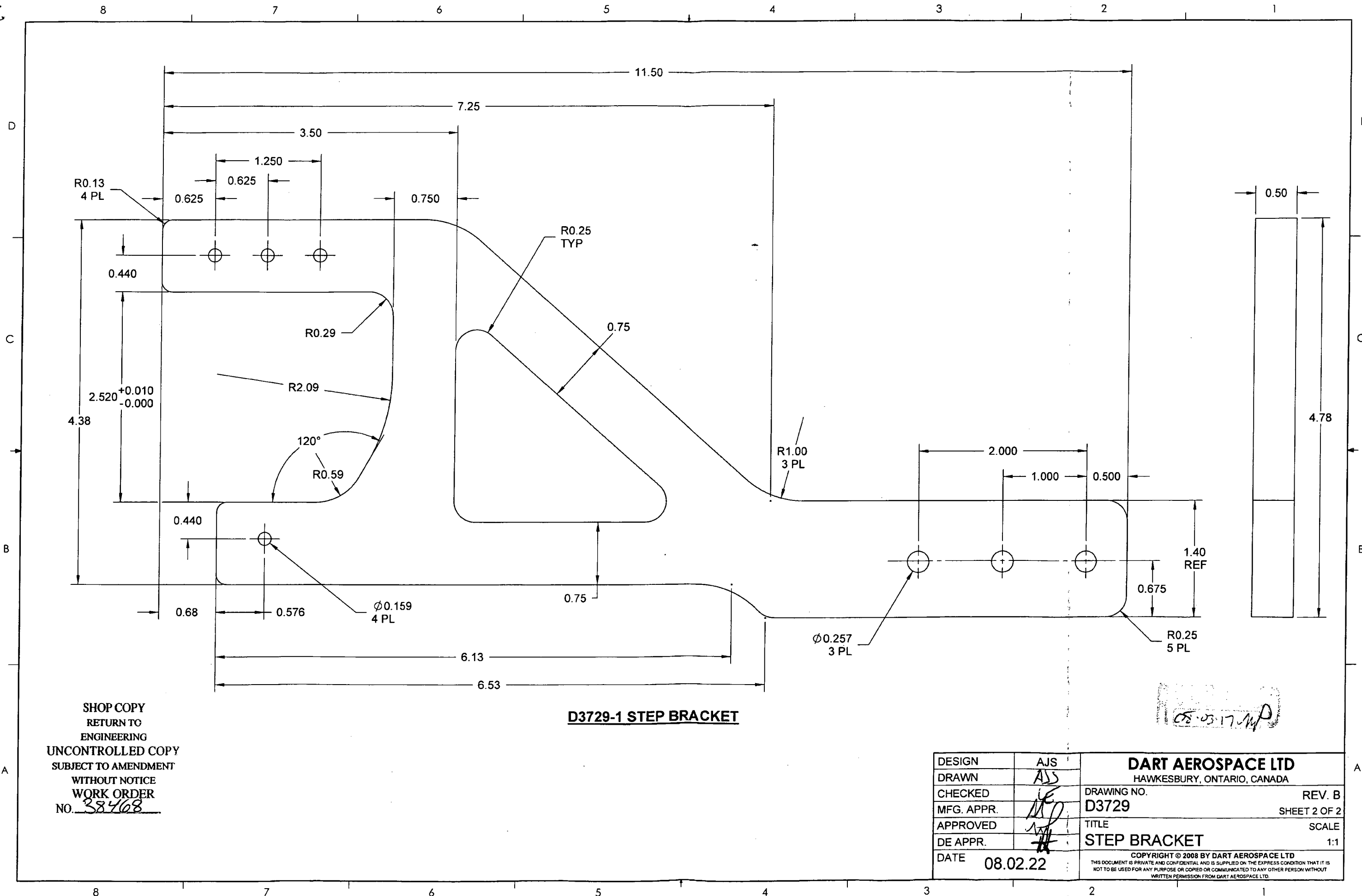


D3729-1 STEP BRACKET

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38468

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.500 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.500)
OR: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF DART SPEC M6061T6B)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.99 lbs

B	SHEET 2 ZONE 4B Ø0.257 HOLE WAS Ø0.191, 8C 2.520 DIM WAS 2.51 & TOLERANCE HAS BEEN UPDATED. ZONE 7B & 7C Ø0.159 HOLES ADDED.	AJS	08.02.22
A	NEW ISSUE	AJS	08.02.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	MA	D3729	SHEET 1 OF 2
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	STEP BRACKET	NTS
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D3729-1 STEP BRACKET

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	MP	DRAWING NO.	REV. B
MFG. APPR.	MP	D3729	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	STEP BRACKET	1:1
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